



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4931-3
Job Sheet 169900



Part No: D4931-3

Job Qty: 4 ea

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/18/18	0.00	0.00	Start Up Machining-3		<i>18/03/18</i>
100	Doosan	4 pcs		1/18/18	0.52	3.96	Doosan		<i>18/03/18</i>
110	QC	4 pcs		1/18/18	0.00	0.00	QC2 Machining-3		<i>18/03/18</i>
112	Mill Conv	4 pcs		1/19/18	0.00	1.53	Mill Conv 1		<i>S.C.</i>
115	QC	4 pcs		1/19/18	0.00	0.00	QC2 Machining-3		<i>S.C. 18/03/18</i>
120	QC	4 pcs		1/19/18	0.00	0.00	QC8 Machining-3		<i>18/03/18</i>
130	Packaging	4 pcs		1/19/18	0.00	0.00	Packaging3-2	<i>5/127</i>	<i>MAR 28 2018</i>
140	QC21-SA	4 Ea		1/19/18	0.00	0.00	QC21		<i>DAS 21 9-00</i>

Part Op 100 - Machine as per folio FB210

Descriptions: 112 - DRILL HOLES AS PER REQUIRED

MAR 28 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R2.000	1	65	0	0

Part Specifications

Specifications could not be found.

Plex 1/3/18 8:57 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	

DART AEROSPACE LTD		Work Order:	169900
Description: EAPS P2 Engine Fitting		Part Number:	D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.057	✓		MJP-04	vern
M.O.W.	Maj: 1.0995 Min: 1.0938	1.097	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	0.130 x 45°	✓			
Ø0.063	+0.004/-0.001	0.065	✓			
0.08	+/-0.030	0.072	✓			
0.906	+/-0.010	0.906	✓			
0.13	+/-0.030	0.131	✓			
0.25	+/-0.030	0.252	✓			
0.938	+/-0.010	0.935	✓			
1.927	+/-0.010	1.933	✓			
0.250	+/-0.010	0.249	✓			
0.424	+/-0.010	0.424	✓			
0.315	+/-0.010	0.315	✓			
0.185	+/-0.010	0.185	✓			
37°	+/-0.5°	37°	✓			
0.33	+/-0.030	0.330	✓			
34°	+/-0.5°	34°				
0.532	+/-0.010	0.532	✓			
1.063	+/-0.010	1.060	✓		MJP-04	vern
0.594	+/-0.010	0.594	✓			
0.791	+/-0.010	0.787	✓		MJP-04	vern
1.188	+/-0.010	1.188	✓			
1.582	+/-0.010	1.582	✓		MJP-04	vern

Measured by: <i>mp/sep.</i>	Audited by: <i>mp</i>	Preliminary Approval:
Date: 18/03/24/18-03-15	Date: 18/03/27	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	<i>[Signature]</i>



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Container No: S047664



Part: D4931-3

Job No: 169900

Serial No/Batch: S047664

Revision:

Inspector:

Date: 03/04/18